

Work Order ID 127182

127182

Jan - 30

Monday, December 15, 2014 8:40:11 AM

Item ID: D3021-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly
 Start Date: 12/15/2014 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 12/31/2014 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: umf Date: 14-12-15 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3021	B

100 Large Fab 0.00
 100 Large Fab Memo 0.00
 Large Fab 1-Cut tube as per Dwg D3021

2-Drill tube as per Dwg D3021 using DT8622

3-Deburr

4-Weld stud and end cap as per Dwg D3021 QSI004
 A/R 4130 Rod Batch: M127925

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110 QC Memo 0.00
 Quality Control

DAS
9
9-89

4 62 14/12/22

(4) 14/12/22

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Item ID: D3021-043 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 12/31/2014 Req'd Qty: 4.00 ***4*** Customer:
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
130	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3	0.00							
130	<i>M 12824</i>								
Powdercoat	Memo	0.00							
Powder Coating	*** MASK THREAD PRIOR TO POWDERCOAT***								
	START TIME: <i>8:10</i>								
	OVEN TEMPERATURE: <i>300°</i>								
	FINISH TIME: <i>8:40</i>								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							DAS 9 9-89
Quality Control									

① 14-12-22 *14-12-23* *① 14-12-23*

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 Start Date: 12/15/2014 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/31/2014 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>St223B</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

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15/1/16 JF
 MF
 15-01-06

Picklist Print

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Work Order ID: 127182

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Parent Item: D3021-043

D3021-043

Parent Item Name: Tube Assembly

Start Date: 12/15/2014

Required Date: 12/31/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.06.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3017-11 *D3017-11* Cap		Manufactured	No			100	Each	51.0000	1	4			
** <u>EL 1/4/12-22</u>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						WA001		51					
						116790		51					
D4667-041 *D4667-041* Armrest Stud Assembly		Manufactured	No			100	Each	4.0000	1	4			
** <u>EL 1/4/12-22</u>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						WA002		4					
						109720		4					
M4130NT0.750W.049 *M4130NT0 750W 049* 4130 RD Tube .750 x.049W		Purchased	No			100	f	158.4160	2.325	10			
** <u>EL 1/4/12-18</u>													
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT033		158.416					
						m122425		22.5					
						m130619		135.916					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

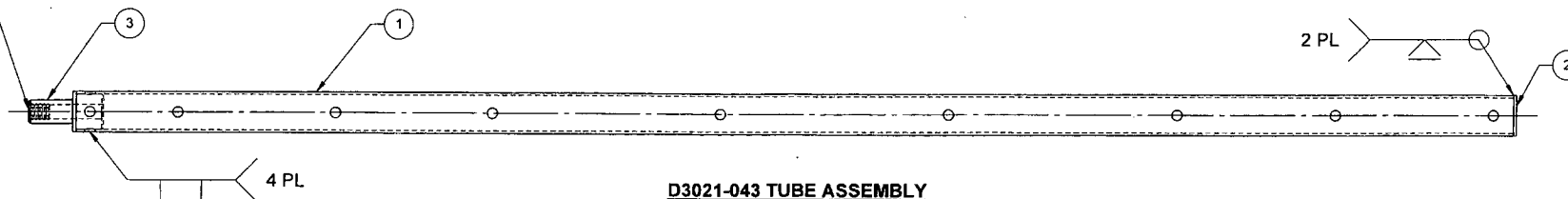
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

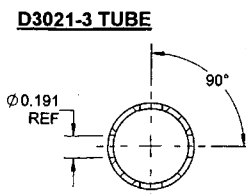
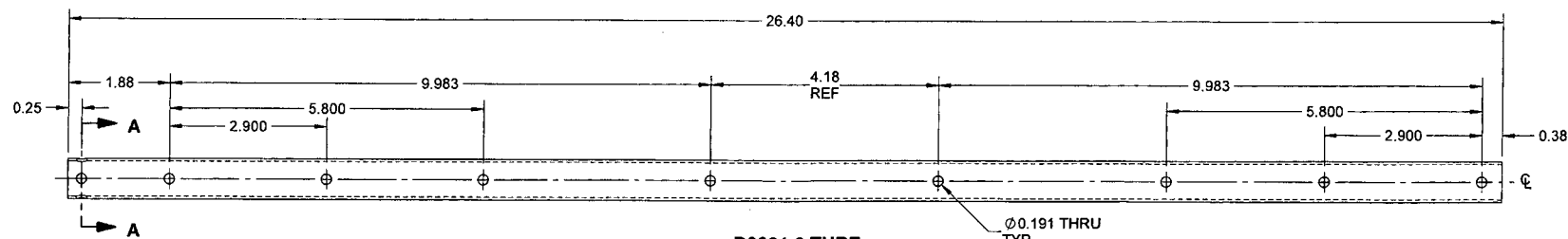
Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

ITEM	-043 QTY	P/N	DESCRIPTION
	X	D3021-043	TUBE ASSEMBLY
1	1	D3021-3	TUBE
2	1	D3017-11	END CAP
3	1	D4667-041	ARMREST STUD ASSY

MASK THREAD PRIOR
TO POWDER COAT



D3021-043 TUBE ASSEMBLY



NOTES:

- 1) MATERIAL -043: N/A
-3: AISI 4130N SEAMLESS STEEL TUBING, $\phi 0.750 \times 0.049$ WALL
PER MIL-T-6736 OR AMS 6371/6360/6361/6362/6373/6374
REF M4130NT0.750W.049
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3021-043" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER).
- 7) WEIGHT: 0.88 lbs

SECTION A-A
SCALE 1:1
RELEASED
2012-07-03

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	[Signature]	DRAWING NO. D3021	REV. B
MFG. APPR.	[Signature]		SHEET 2 OF 2
APPROVED	[Signature]	TITLE TUBE ASSEMBLY	SCALE NTS
DE APPR.	[Signature]	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE REPRODUCED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	12.06.12		